

Date: Thursday, 5/3/2007 11:37:46 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : UPPER AND LOWER PLATE  
 Job Number : 32193  
 Estimate Number : 12837  
 P.O. Number : N/A Part Number : D35241  
 This Issue : 5/3/2007 S.O. No. : N/A Drawing Number : UNDER REVIEW C.B. 07.05.04  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : N/A  
 Previous Run : N/A Material : N/A  
 Written By : Due Date : 5/28/2007 Qty: 3 Um: Each  
 Checked & Approved By : *07.05.04*  
 Comment : Est Rev:A New Issue 07-04-18 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X02000 6061-T6 Bar .25" X 2.0"



Comment: Qty.: 0.2100 f(s)/Unit Total: 0.6300 f(s)  
 6061-T6 Bar .25" X 2.0"  
 batch: M15949 *md 07/05/05* 3

2.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE *md 07/05/05* 3

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE *md 07/05/05* 3

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK *ms 07/05/05* 3

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1 *md 07/05/14* (3)

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 *md 07/05/15* (3X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes NO DQA: 12 Date: 07/05/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: UPPER AND LOWER PLATE

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*EP 07/15/16 (3)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP 07/15/16 (3)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



*(3)*

Comment: FINAL INSPECTION/W/O RELEASE

*EP 07/15/16*

Job Completion



*W 07-05-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

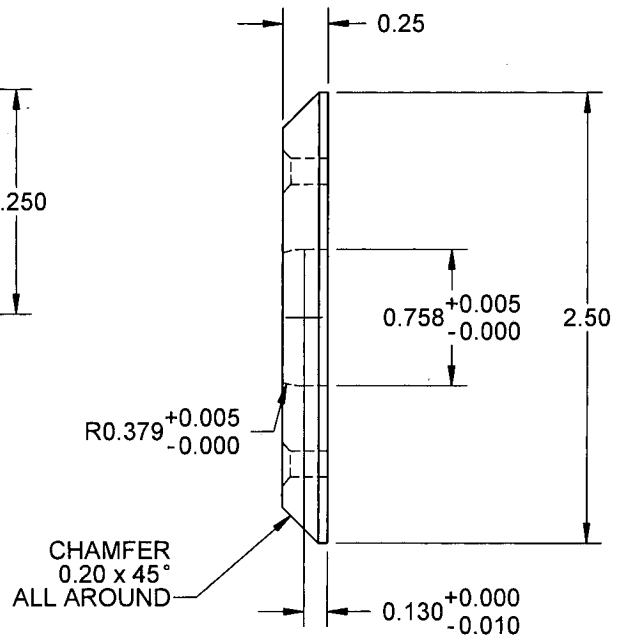
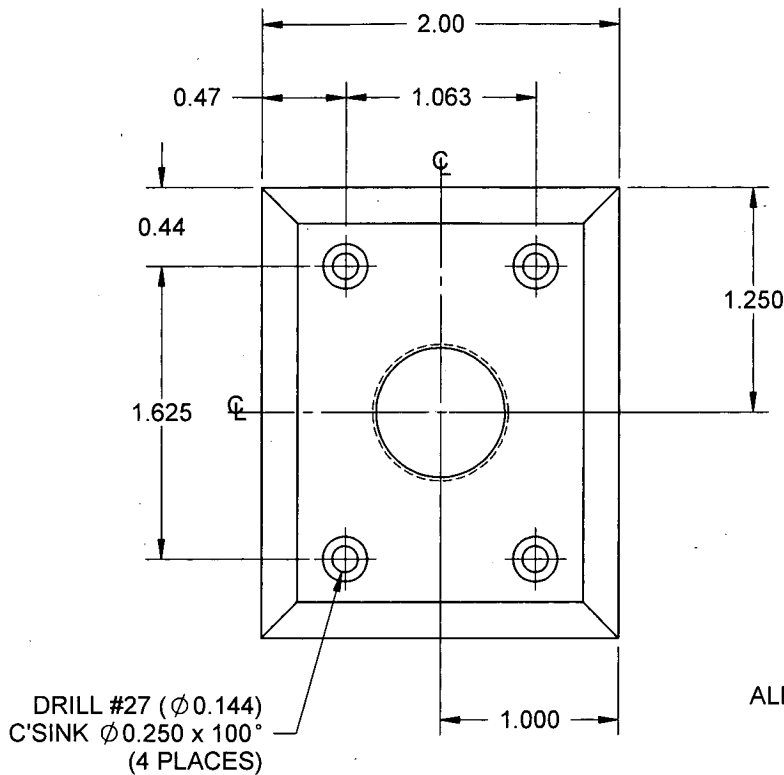
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3524	REV. A SHEET 1 OF 3
DATE 07.01.10		TITLE UPPER AND LOWER PLATE	SCALE 1:1
REV A	DATE 07.01.10	DESCRIPTION NEW ISSUE	

UNDER REVIEW  
07.05.04 CB  
dwg not released



### D3524-1 LOWER PLATE

#### NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS-4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT  $\phi$

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 32193

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32193
<b>Description:</b> LOWER PLATE	<b>Part Number:</b> D3524-1
<b>Inspection Dwg:</b> D3524 Rev: A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	$\pm 0.30$	1.999	—			
1.250	$\pm 0.16$	1.250	—			
1.000	$\pm 0.16$	0.999	—			
$\varnothing 0.144$	$\pm 0.004$ $\pm 0.001$	$\varnothing 0.144$	—			
$\varnothing 0.250 \times 100^\circ$	$\pm 0.16$	$\varnothing 0.250 \times 100^\circ$	—			
1.625	$\pm 0.05$	1.627	—			
0.44	$\pm 0.030$	0.441	—			
0.47	$\pm 0.30$	0.470	—			
1.063	$\pm 0.05$	1.063	—			
0.25	$\pm 0.36$	0.247	—			
2.50	$\pm 0.36$	2.500	—			
0.758	$\pm 0.005$ $\pm 0.000$	0.763	—			
R0.379	$\pm 0.005$ $\pm 0.000$	R0.379	—			
0.20x45°	$\pm 0.36$	0.203x45°	—			
0.130	$\pm 0.000$ $\pm 0.10$	0.130	—			

<b>Measured by:</b> <i>gml</i>	<b>Audited by:</b> <i>br</i>	<b>Prototype Approval:</b>
<b>Date:</b> 07/05/05	<b>Date:</b> 07/05/05	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	